

05/10

Work Order ID 52618

October 5, 2009 8:09:20 AM

Page 1

Item ID: D3163-041 *GY*

Accept

Revision ID: D

Item Name: Cover Assembly

Start Date: 10/05/09 Start Qty: 3.00

Required Date: 10/06/09 Req'd Qty: 3.00

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3163

Rev D

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Rivet D3163-3 to D3163-1.
Ensure holes line up

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 11:15
OVEN TEMPERATURE: 320°
FINISH TIME: 12:45

BL 09-10-06

09/10/06 (3)

(43)

(3)

Work Order ID 52618

October 5, 2009 8:09:20 AM



Page 2

Item ID: D3163-041
Revision ID: D
Item Name: Cover Assembly

Accept



Setup Start



Stop



Start Date: 10/05/09 Start Qty: 3.00

Required Date: 10/06/09 Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

EP 09/10/06 (3)

140



Small Fab

Small Fab

Small Fab

Memo

Install Nutplates as per Dwg D3163

0.00

0.00

EP 09/10/06 (3)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 Sorlos

(3) /

Work Order ID 52618

October 5, 2009 8:09:21 AM



Page 3

Item ID: D3163-041
Revision ID: D
Item Name: Cover Assembly

Accept



Setup Start



Stop



Start Date: 10/05/09 Start Qty: 3.00



Required Date: 10/06/09 Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

COMP

0.00

Packaging

09/10/06

Handwritten signature

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/07

Handwritten signature

Picklist Print

October 5, 2009 8:09:19 AM

Page 1

Work Order ID: 52618

Parent Item: D3163-041RevD

Parent Item Name: Cover Assembly



Comments:

Start Date: 10/05/09

Required Date: 10/06/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3163-1RevD		Manufactured	No			100	Each	2.0000	3.0000			
												
Plate												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

50398

2

2

D3163-3RevD		Manufactured	No			100	Each	0.0000	3.0000			
												
Plate												
MS20426AD3-4		Purchased	No			100	Each	8,197.000	12.0000			
												
RIVET												

B52617

(3x)



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

104374

110398

8197

4197

4000

MS20426AD3-4		Purchased	No			140	Each	8,197.000	12.0000			
												
RIVET												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

104374

110398

8197

4197

4000

EP09/10/09
B52621 (3A)

EP09/10/09

EP09/10/09

EP09/10/09

12

12

Picklist Print

October 5, 2009 8:09:19 AM

Page 2

Work Order ID: 52618

Parent Item: D3163-041RevD

Parent Item Name: Cover Assembly

Comments:

Start Date: 10/05/09

Required Date: 10/06/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21059L08		Purchased	No			140	Each	229.0000	6.0000			



Nut



9/30/09 10/06

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

229

112314

200

12706

29

6

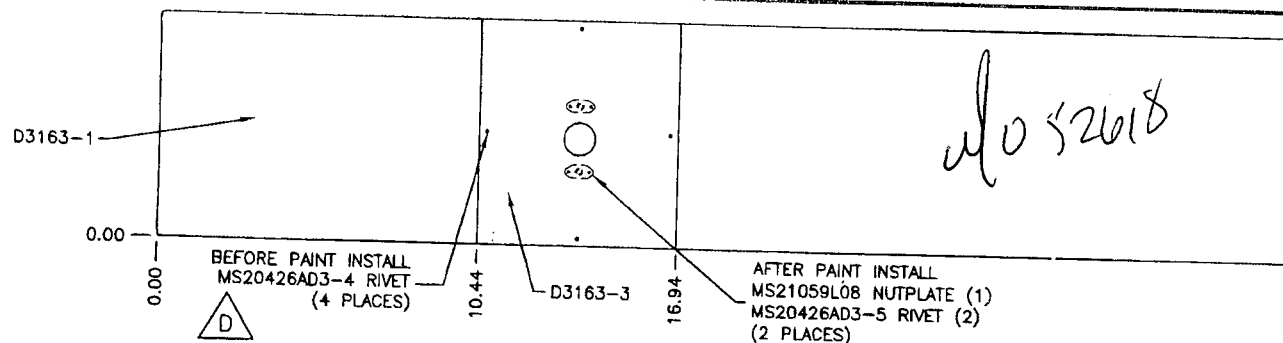
October 5, 2009 8:09:19 AM

Shop Packet Print

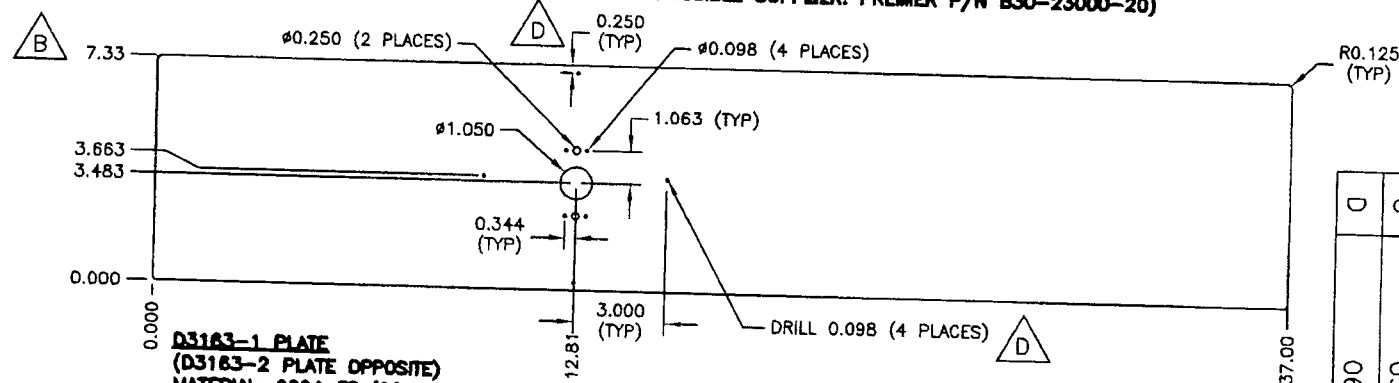
Page 2

66-66-29-11

4052618



D3163-041 PLATE SHOWN. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-19
(D3163-042 PLATE OPPOSITE. POSSIBLE SUPPLIER: PREMIER P/N B30-23000-20)

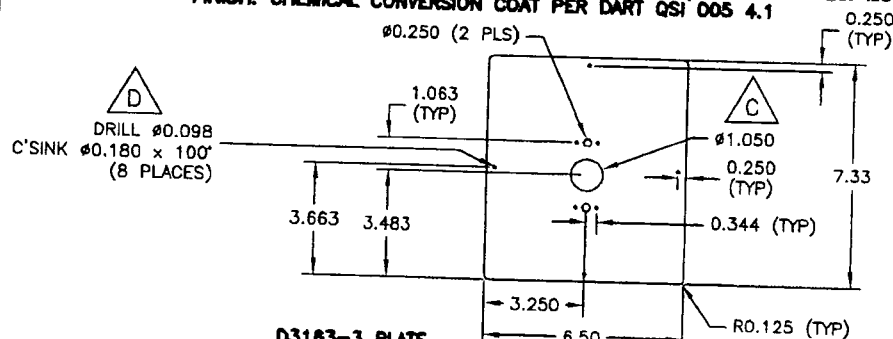


D3163-1 PLATE

(D3163-2 PLATE OPPOSITE)

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (REF. DART SPEC. M2024T3S.032) OR
8061-T8 (QQ-A-250/11) 0.032 THICK (REF. DART SPEC. M8061T8S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

FINISH: CHEMICAL CONVERSION COAT PER DART SPEC. M6081TBS.032)



D3163-3 PLATE

MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063) OR
8061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M8061T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 003 4.1

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 003 4.1

GENERAL NOTES:

- 1) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3 AFTER ASSEMBLY OF D3163-3 PLATE BUT BEFORE INSTALLATION OF MS21059L08 NUTPLATES
- 2) BREAK SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

DESIGN	RF	DRAWN BY	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#1	APPROVED	#1	DRAWING NO.	REV. 0
DATE	06.06.26	TITLE	PLATE	D3163	SHEET 1 OF 1
A	02.04.26	NEW ISSUE	SCALE	1:6	
B	04.10.06	7.33 WAS 7.20; REMOVE PERIMETER HOLES			
C	05.11.22	Ø1.050 WAS Ø1.000			
D	06.06.26	ADD 4 RIVETS; REMOVE ADHESIVE			

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 2002 by DART AEROSPACE LTD
AND IS SUBMITTED ON THE BEHALF OF